

Work Order ID 90915

90915

Page 1

Wednesday, October 17, 2012 2:34:21 PM

Item ID: PB67-43001-203

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Square Tube

Start Date: 9/27/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 10/5/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: WLF

Date: 12-10-20

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
B67-43001	C

100

0.00

100

Small Fab

Small Fab

Memo

0.00

Small Fab

1- cut to length as per dwg
2- deburr

6

φ

Ac 12.11.13

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

0.00

Quality Control

DAS
16

12/11/14

1

6

φ

DAS
23

12.11.13

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Wednesday, October 17, 2012 2:34:21 PM

Item ID: PB67-43001-203

Accept

N9000040100

Setup Start

NS1

Revision ID:

Item Name: Square Tube

Stop

NS2

Start Date: 9/27/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 10/5/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

0.00

120

CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

1- drill holes as per dwg

2- make a chamfer on both side of the 2 holes as per dwg

3- deburr

130

0.00

130

QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

180

0.00

180

Identify as per dwg & Stock Location: 446A

Packaging

Memo

0.00

Packaging

12-11-20

DAS
15
9-28
12/1/20

6

12/1/21

Work Order ID 90915***90915***

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Wednesday, October 17, 2012 2:34:21 PM

Item ID: PB67-43001-203

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Square Tube

Stop ***NS2***

Start Date: 9/27/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 10/5/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

12/11/22 *[Signature]*

mc

12-11-21

Picklist Print

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Work Order ID: 90915

Parent Item: PB67-43001-203

Start Date: 9/27/2012

Required Date: 10/5/2012

Parent Item Name: Square Tube

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 08-06-26 new issue DD verified by:ec
EC verified by DD

IPP Rev B 10.10.05 per RevC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6TS1.000W.120

Purchased

No

100

f

99.7100

1.6042

10.131789

6061T6 SQ TUBE 1.00 x 1.00 X .120w

DA
22
28 12.10.23

1123552 → 10.131789

Ac 12.11.13

Location

Loc Qty

Loc Code

MAT

21.71

109057

0

110680

21.71

MAT028

78

115775

78

8

7

6

5

4

3

2

1

D

D

C

C

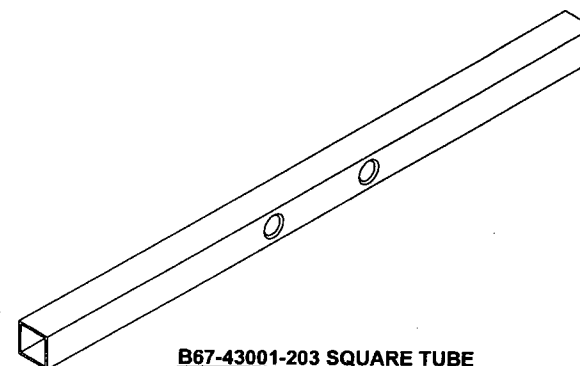
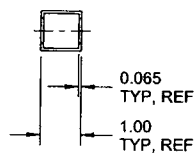
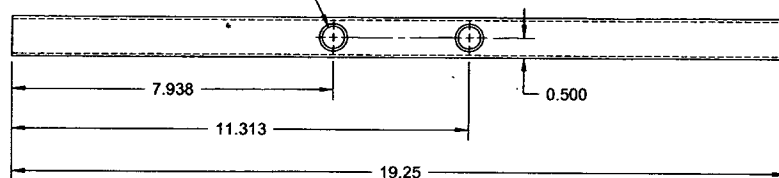
B

B

A

A

Ø0.563 THRU
Ø0.693 X 45° CHAMFER
TYP, BOTH SIDES
2 PL



B67-43001-203 SQUARE TUBE

#90915

RELEASED
2009-09-24
MP

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) SQUARE TUBING
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF. DART SPEC. M6061T6TS1.000W0.065
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.45 lbs

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO PAGE 16 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	09.02.19
REV.	DESCRIPTION		BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	LS			
CHECKED	LS	DRAWING NO.		REV. C
MFG. APPR.	LS	B67-43001-203		SHEET 1 OF 1
APPROVED	MP	TITLE		SCALE
DE APPR.	N/A	SQUARE TUBE		NTS
DATE	09.02.19	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		